



Dart Aerospace Ltd.
1270 Aberdeen St
Hawkesbury, ON
K6A 1K7
Canada

Tel (613) 632-5200

RBE-350HYD
Job Sheet 175598



Part No: RBE-350HYD

Job Qty: 3 ea

Part Name: Hydraulic Accumulator Fitting Gauge



Part Weight: 0 lbs

Status: Scheduled

Priority: Medium

Job Created: 4/9/18

Job Tracking No:

Due Date: 4/10/18

Created By: Linda Lacelle

Type: Stock

Description:

Note: DWG RBE-350HYD REV:2 IPP REV:A 18.01.16 NEW ISSUE RQ VERIFIED BY: DP

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup hrs	Run Hrs	Workcenter / Supplier	Lead Time	
90	Start up Operation	3 Ea		4/9/18	0.00	0.00	Start Up Small Fab-4		MLC
100	Small Fab	3 pcs		4/10/18	0.08	0.25	Small Fab-9		MLC DAS
110	QC	3 pcs		4/10/18	0.00	0.00	QC5		38
130	Packaging	3 pcs		4/10/18	0.00	0.00	Packaging3-2		18-88-16
140	QC21-FG	3 Ea		4/10/18	0.00	0.00	QC21		GA 141

Part Op **100** - 1- Engrave T/N And / or S/N number as required Using Marktronic engraver as per DWG. 2- Assemble as per dwg.
Descriptions: 3- Assemble using permatrix thread sealant or equivalent as per note 2
130 - Identify and Stock

DAS
21
2-85

APR 17 2018

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
4053K751	Pressure Gauge, 0-300 Psi	3 Ea (1 ea)	90-Start up Operation	
AMF556	Bleeder	3 Ea (1 ea)	90-Start up Operation	
PAR211P-4	1/4 NPT Square Plug	3 Ea (1 ea)	90-Start up Operation	
PAR2203P-4	1/4 NPT Female "T" Fitting	3 Ea (1 ea)	90-Start up Operation	
PAR209-4-2	1/4 NPT to 1/8 NPT Reducer Fitting	3 Ea (1 ea)	90-Start up Operation	

Job Allocations

Operation	Component Part	Required	Inventory	Allocated
90-Start up Operation	4053K751	3	7	0
	AMF556	3	3	0
	PAR209-4-2	3	6	0
	PAR211P-4	3	6	0
	PAR2203P-4	3	6	0

Part Specifications

Specifications could not be found.

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

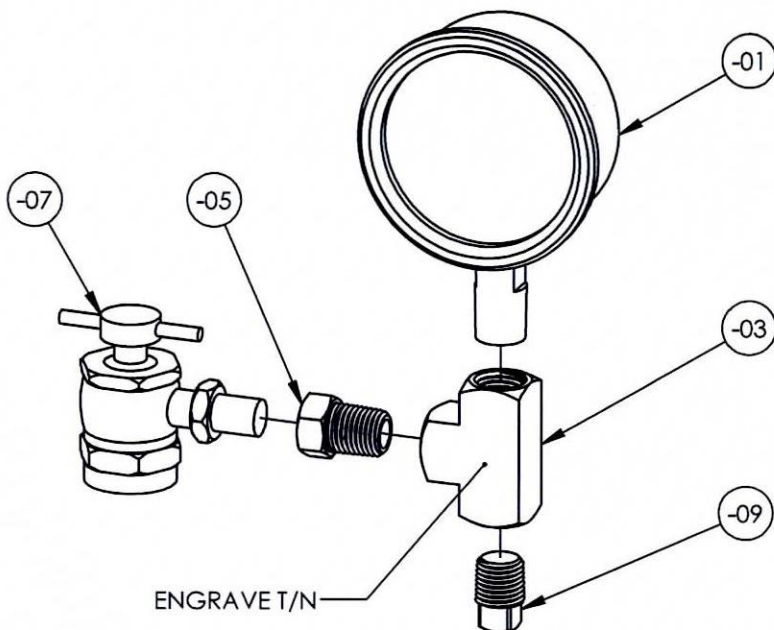
Work Order update only ☐

DART AEROSPACE Container No: S059160  Part: RBE-350HYD Job No: 175598 Serial No/Batch: S059160 Revision: 2 Inspector: _____ Date: 04/09/18	DISPOSITION Dart Aerospace Ltd. 1270 Aberdeen Street Hawkesbury, ON K64 1K7 CANADA TEL.: 1 613 632-5200 Email: sales@dartaero.com www.dartaerospace.com	AGAINST DEPARTMENT/PROCESS <table style="width: 100%;"> <tr> <td style="width: 15%;">rk ☐</td> <td style="width: 15%;">Skid-tube ☐</td> <td style="width: 15%;">Cross tube ☐</td> <td style="width: 15%;">Water Jet ☐</td> <td style="width: 15%;">Engineering ☐</td> </tr> <tr> <td>ip ☐</td> <td>Machining ☐</td> <td>Small Fab ☐</td> <td>Prod. Eng. Coord. ☐</td> <td>Quality ☐</td> </tr> <tr> <td>is ☐</td> <td>Thermoforming ☐</td> <td>Finishing ☐</td> <td>Rec/Store/Packaging ☐</td> <td>Other ☐</td> </tr> <tr> <td>ed ☐</td> <td>Large Fab ☐</td> <td>Composite ☐</td> <td>Supplier ☐</td> <td></td> </tr> </table>				rk ☐	Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	ip ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	is ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	ed ☐	Large Fab ☐	Composite ☐	Supplier ☐										
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		Disposition		Completed By																														
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				QC / QA Coordinator Approval																														
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Misidentified ☐	Past Due ☐																																	

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REVISIONS					
REV	ECR	DESCRIPTION	DATE	INITIAL	APPROVED
1		DESIGNED PER HELI PRODUCTS TOOLS.	9/28/2009	WP	DW
1A		ADDED NOTE 2 TO USE PERMATAX THREAD SEALANT PER D.W.	5/9/2012	RJC	DW
1B		-01 CH'D GAUGE WAS PACIFIC RUBBER #W1K9692040 IS PARAMOUNT SUPPLY #ASHCROFT 1008.	3/24/2014	RJC	RW
1C	14-0213	CH'D TITLEBLOCK WAS RED BARN IS DART. RE-DRAWN IN SOLIDWORKS. ADDED ENGRAVE T/N NOTE. -01 CH'D B/O INFO WAS #ASHCROFT 1008 IS #63-1008-S-02L-300#-XLL.	11/12/2014	DPD	JAG
2	16-0145	-01 CH'D B/O REF WAS PARAMOUNT SUPPLY #63-1008-S-02L-300#-XLL IS MCMASTER-CARR #4053K751.	9/12/2016	DPD	JAG

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RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 170541 MGS
18017
17559B



NOTES:

1. FUNCTION: USED TO TEST AND REFILL ACCUMULATORS.
2. ASSEMBLE USING PERMATAX THREAD SEALANT OR EQUIVALENT.
3. ALSO IN KIT RBEA62309.

DART AEROSPACE	
TITLE HYD. ACCUM. FITTING GAUGE	
DWG NO. RBE-350HYD	REV 2
MAT'L TREAT FINISH SPEC	UNLESS OTHERWISE SPECIFIED DIMENSIONS ARE IN INCHES .XXX ± .005 FRACTIONS ± 1/16 .XX ± .01 ANGLES ± .5° .X ± .1 SURFACES = 125/✓
DRAWN BY: PERRITT	1. BREAK ALL SHARP EDGES .015 x 45° OR .015R
CHECKED: MACKOVJAK	2. DIMENSIONAL LIMITS APPLY AFTER PLATING
OPPS APPR: ANDERSON	3. INTERPRET DIM AND TOL PER ASME Y14.5M-2009
QA APPR: LINDSAY	USED ON MODEL
APPROVED: GILBERT	EUROCOPTER AS350/355
SCALE 1:2	DATE 9/9/2009 SHEET 1 OF 1

ASSY QTY	ASSY QTY	B/O	Part #	UNIT QTY	Description	Material	B/O INFORMATION OR SPECIFICATIONS	P.G.
		B/O	-01	1	PRESSURE GAUGE, 0-300 PSI		0-300 psi (0-2,000 kPa) (MCMASTER-CARR #4053K751)	1
		B/O	-03	1	1/4 NPT FEMALE 'T' FITTING	BRASS	(PACIFIC RUBBER #PAR2203P-4)	1
		B/O	-05	1	1/4 NPT TO 1/8 NPT REDUCER FITTING	BRASS	(PACIFIC RUBBER #PAR209-4-2)	1
		B/O	-07	1	SCHRADER VALVE	S.S.	(PACIFIC RUBBER #AMF556)	1
		B/O	-09	1	1/4 NPT SQUARE PLUG	BRASS	(PACIFIC RUBBER #PAR211P-4)	1

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐	AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐			
Date :	Step #:	QTY Effective :		MRB (QSI042) Approval	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor Approval Verification	
				QC / QA Coordinator Approval	
Root Cause		FAULT CATEGORY			
Environment ☐	No Re-verification ☐	Pressure/Forced ☐	Temperature/Cure ☐	Power Loss/Surge ☐	Positioned Wrong ☐
Design ☐	Operator ☐	Bending ☐	Set-up ☐	Folio/Program ☐	Outside Dimensions ☐
Doc/Data ☐	Offset/Setup ☐	Centre Not Concentric ☐	BOM/Route ☐	Grain ☐	Over/Under tolerance ☐
Equip/Tooling ☐	Supplier ☐	Cracks ☐	Broken/Damage/Defect ☐	Weld ☐	Part Incorrect ☐
Handling/Pre ☐	Training ☐	Crimp/Kink/Ripple/Wave ☐	Inspection Incomplete/Unqualified ☐	Wrong Stock Pulled ☐	Part Lost/Missing ☐
Material ☐	Use for Testing ☐	Cuffs ☐	Contamination ☐	Out of Sequence ☐	Part Moved ☐
Internal Transport ☐	Poor Information ☐	Crushing ☐	Countersink ☐	Off-set ☐	Drawing ☐
Tribal Knowledge ☐	Rushing ☐	Heat Treat ☐	Cut Too Short ☐	Mislabeled ☐	Finish ☐
LOA ☐	Product Improvement ☐	Wave/Twist in Tube ☐	Instructions Incomplete/Unclear ☐	Fit/Function ☐	Misread ☐
Substation ☐	Process Improvement ☐	Marks/Chatter ☐	Drill Holes ☐	Misaligned/off center ☐	Turning Sequence ☐
Past Expiry Date ☐	Manufacturing Process ☐	OTHER : _____			
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